



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-796-151
Job Sheet 190019



Part No: D119-796-151

Job Qty: 1 pcs

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 4/5/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV:C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV:PC6 DD VERF:JLM IPP
REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD
VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Crosstubes - 1	1 pcs	4/5/19		0.00	0.49	Crosstubes - 1		
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		AR 19-6-25
140	QC 5	1 pcs	4/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
145	DC - 1 - B4B	1 pcs	4/5/19		0.00	0.00	DC - 1 - B4B		
							DC - 2 - B4B		
150	Packaging 3-1 - Stock - B4B	1 pcs	4/5/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S196581



Part: D119-796-151

Job No: 190019

Serial No/Batch: S196581

Revision: F/G

Plex 4/8/19 12:10 PM Dart.Hadley.Shannon

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	1819-7-9
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160	QC 21 - FG	1 pcs	4/5/19	0.00 0.00	QC 21 - FG - 21	DAC 21 JUL 10 2019
					QC 21 - FG - 70	9:55
					QC 21 - FG - 53	
Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.*** Descriptions: 140 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.*** 145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 005 150 - (Identify as per dwg & Stock Location: <u>L6050</u>) Identify and pack for shipping as per PPP D119-796-151 160 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D119-796-141	Fwd Crosstube Installation Without Step (No Hardware)	1 pcs (1 ea)	130-Crosstubes - 1			
D5123-3	Clamp Cushion	4 pcs (4 ea)	130-Crosstubes - 1			
D5149-041	Fwd Step Base Assembly	2 pcs (2 ea)	130-Crosstubes - 1			
MS21920-22	Clamp	4 Ea (4 ea)	130-Crosstubes - 1			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
130-Crosstubes - 1	D119-796-141 187563	① 4	2	0		
	D5123-3	② 172135	193	0		
	D5149-041	③ 172135	5	0		
	MS21920-22	④ 171289 ④ → 13054p	41	0		
Part Specifications						
Specifications could not be found.						



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/5/19	4/5/19	0.00	0.00	Start Up Crosstubes-1		
130	Crosstubes	1 pcs	4/5/19	4/5/19	0.00	0.49	Crosstubes-1		
140	QC	1 pcs	4/5/19	4/5/19	0.00	0.00	QC5		
145	DC	1 pcs	4/5/19	4/5/19	0.00	0.00	DC		
150	Packaging	1 pcs	4/5/19	4/5/19	0.00	0.00	Packaging3-1		
160	QC21-FG	1 Ea	4/5/19	4/5/19	0.00	0.00	QC21		

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 005
150 - Identify and pack for shipping as per PPP D119-796-151

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-141	Fwd Crosstube Installation Without Step (No Hardware)	1 pcs (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 pcs (4 ea)	90-Start up Operation	
D5149-041	Fwd Step Base Assembly	2 pcs (2 ea)	90-Start up Operation	
MS21920-22	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-141	1	0	0
	D5123-3	4	205	0
	D5149-041	2	5	0
	MS21920-22	4	28	0

Part Specifications

Specifications could not be found.

Plex 2/4/19 10:53 AM dart.white.jesse

Andrew Sheldon

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					